



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

D119-796-251
Job Sheet 174933



Part No: D119-796-251

Job Qty: 1 ea

Part Name: Aft Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 5/28/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D119-796-251 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B 14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D JLM VERF:DD IPP REV:F 17.12.11 REMOVE PACK KIT DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/26/18	0.00	0.00	Start Up Crosstubes-1		A8 MAY 07 2018
130	Crosstubes	1 pcs		5/28/18	0.00	0.51	Crosstubes-1		A8 MAY 07 2018
140	QC	1 pcs		5/28/18	0.00	0.00	QC5		38 MAY 07 2018
145	DC	1 pcs		5/28/18	0.00	0.00	DC		A8 MAY 07 2018
150	Packaging	1 pcs		5/28/18	0.00	0.00	Packaging3-1 LG050		A8 MAY 07 2018
160	QC21-FG	1 Ea		5/28/18	0.00	0.00	QC21		21 MAY 08 2018

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-251 ***Torque all clamps to 50 IN-LBS max.***

Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***

145 - Photocopy bluefile and create labels as per PPP D119-796-251 chg 004

150 - Identify and pack for shipping as per PPP D119-796-251

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-241	Aft Crosstube Installation Without Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	
D5123-3	Clamp Cushion	4 Ea (4 ea)	90-Start up Operation	
D5149-043	Aft Step Base Assembly	2 Ea (2 ea)	90-Start up Operation	
MS21920-25	Clamp	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-796-241 173744 5048522	①	10	0
	D5123-3 5006028	④	318	0
	D5149-043 5039113	② (5063953)	10	0
	MS21920-25 5050048	④	144	0



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Container No: S068892



Part: D119-796-251

Job No: 174933

Serial No/Batch: S068892

Revision: E/F

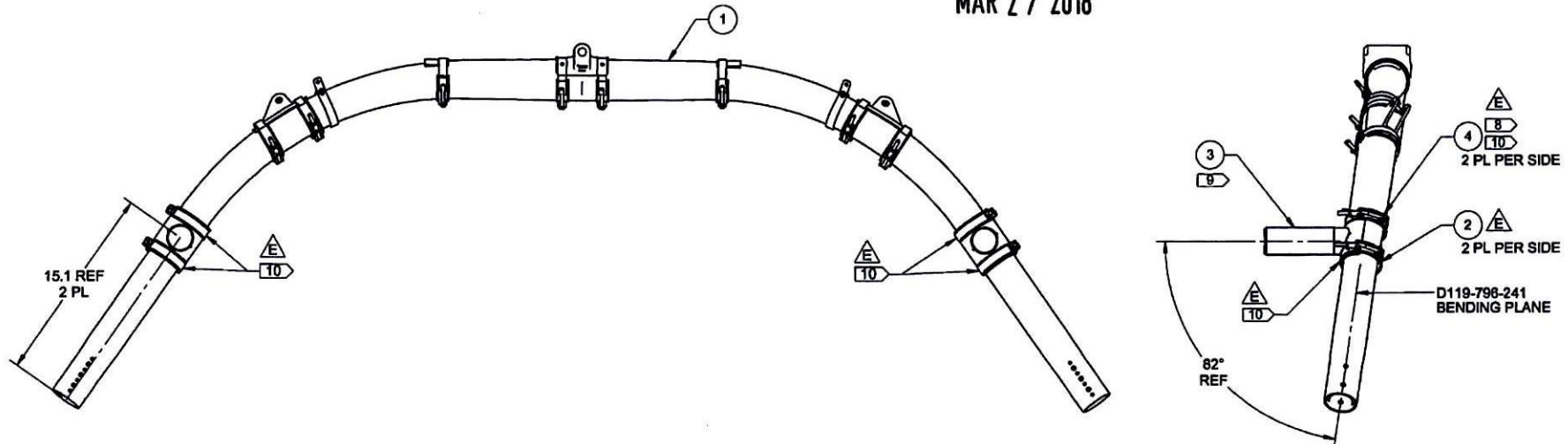
Inspector:

1:59 AM Dart.Gagnon.Michelle

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 174933

MAR 27 2018

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE
- 10) POSITION MS21920 CLAMPS SECURING THE STEPS AS SHOWN. THE THREADED PORTION OF THE CLAMP MUST FACE THE SAME DIRECTION AS THE STEP

RELEASED
2017-05-04
ECN 17-538

E	MODIFY CLAMP ORIENTATION, ADD NOTE 10, REMOVED SECTION A-A (PAR16-527)		ML	17.02.10	
D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A		AP	15.01.18	
C	RE-DESIGN STEP INSTALLATION		DB	14.11.24	
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A		AP	14.10.04	
A	NEW ISSUE		AP	14.09.03	
REV.			DESCRIPTION	BY	DATE
DESIGN		AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		ML			
CHECKED		NO			
MFG. APPR.		DD			
APPROVED		WM			
DE APPR.		DS	DRAWING NO. D119-796-251		
DATE		17.02.10	TITLE XTUBE ASSY (AW119 MKII AFT)		
			SCALE NTS		
			REV. E SHEET 1 OF 1		
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